

**PRODUCT BULLETIN
GYPSUM PRODUCTS****ARIDIZED PLASTER
BASE STUCCO****BULLETIN NO:** S-5
DATE: 10/8/65
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CANCELS: S-5
DATE: 11/5/62

This bulletin covers operating specifications, product specifications, and required tests for manufacture of calcined gypsum stucco for aridized stucco based hardwall plasters.

PRODUCING PLANTS: Antioch and Seattle

USES: Aridized Stucco Base Dual Purpose Hardwall (Bulletin P-1A)
Aridized Stucco Base Red-E-Mix Plaster (Bulletin P-6A)

OPERATING SPECIFICATIONS: Refer to Stucco Products, Kettle Operating Specifications, Bulletin SG-1, for general operating specifications. Specific specifications are listed below.

1. Type 4 Ground Raw Gypsum (Bulletin R-3) shall be used for manufacture of aridized hardwall base stucco.

2. Kettle calcination cycle shall be held within the following limits:

Time of Fill, maximum (minutes) 45

Dump Temperature (° F) 340 - 365

Total Time Cycle (hrs.) 2:15 - ~~2:00~~ ^{7:30}

3. Aridize with calcium chloride solution prepared as specified in Bulletin SG-1. Calcium chloride usage shall be adjusted as required within a range of 0.5 to 2.0 lbs. per ton of ground raw gypsum to meet normal consistency and strength requirements.

Usage Specifications (lbs./ton ground raw gypsum): Liquid 1.4 - 5.6
Dry 0.6 - 2.6

PRODUCT SPECIFICATIONS:

	Hot Pit	Reground
Combined Water (%)	5.3 - 5.7	5.5 - 6.0
Normal Consistency (c.c.)	70 - 74	87 - 91
Time of Set, Vicat (minutes)		
Antioch	30 - 50	30 - 50
Seattle	25 - 45	25 - 45
Surface Area (Blaine)	1600 - 2200	4700 - 5500
Compressive Strength, min. (psi)		
3 Hrs. after Set	400	500
Dry	900	1000